

Date: Wednesday, 24/09/2008 12:47:49 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TUBE
Job Number	: 42265		
Estimate Number	: 12773		
P.O. Number	:	Part Number	: 41232 200 002 001
This Issue	: 24/09/2008 S.O. No. :	Drawing Number	: 41232-200-002 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 36247	Material	:
Written By	:	Due Date	: 20/10/2008 Qty: 4 Um: Each
Checked & Approved By	: <u>JL 08.9.24</u>		
Comment	: Est Rev:A New Issue 07-03-05 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3H1375	2024-T3 Hex Bar 1.375"
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Comment: Qty.: 0.4550 f(s)/Unit Total: 1.8199 f(s)

2024-T3 Hex Bar 1.375"

Batch: 1106650mmf 08/10/03

2.0	LATHE CONV.	CONVENTIONAL LATHE
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Comment: CONVENTIONAL LATHE

Turn as per Dwg 41232-200-0021

TURN BORE TAP DRILL 45/64" AND TAP 3/4"20

mmf 08/10/03

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1.
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA687 Rev: A & Dwg 41232-200-002 Rev: A

2-Deburr

JL 08/10/18

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 08/10/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 41232-200-002-001 PAR #: N/A Fault Category: Prod - Mach NCR: Yes No DQA: AS Date: 08.11.03
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: AS Date: 08/11/11

NCR: <u>42265</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/10/18</u>	<u>1</u>	<u>1 part has marks in 375 slot with .063 rad</u> <u>Root Cause:</u> <u>rad tool was not programmed correctly causing it to rub on each side</u>	<u>bsi/uz</u>	<u>Scrap: destroy 1 part.</u> <u>Also correct the program</u> <u>: verify.</u>	<u>J.L</u> <u>08/10/18</u>	<u>AS</u> <u>08/10/20</u>	<u>bsi/uz</u>	<u>08-10-20</u>

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 42265

Part Number: 41232 200 002 001

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SP 08/10/20

7.0

OUTSIDE SERV.30

OUTSIDE SERVICES-MACH



Comment: Sub-Contracting PURCHASING

Issue P/O: 7433

Black Anodize as per Dwg 41232-200-005

Ensure Certificate of Conformity is attached

C 208 10/23
(3)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

P 08/10/30 (3)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 08/10/30 (43)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

S 08/10/31 (3)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/03

Job Completion



u 08/10/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 42265
Description: tube		Part Number: H1232-200-002-001
Inspection Dwg: H1232-200-002, Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

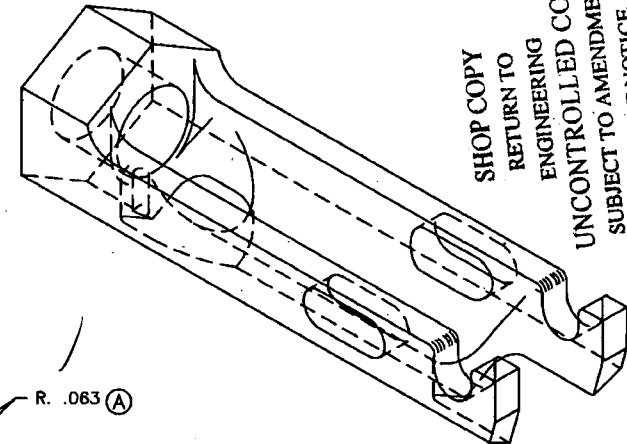
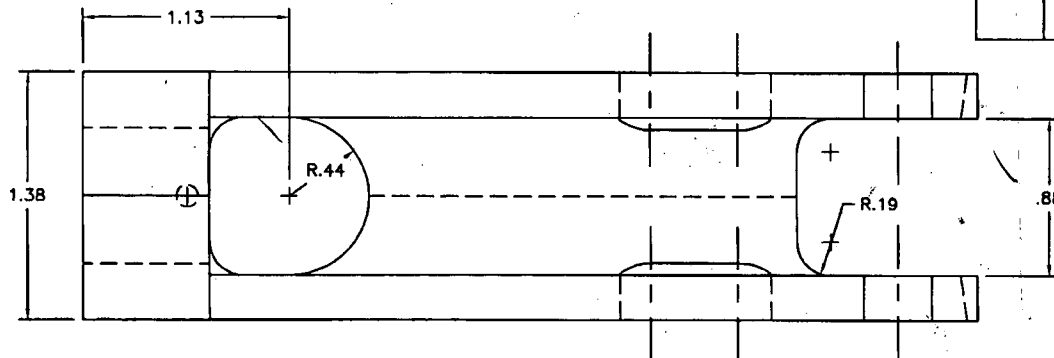
☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .88	+ .006 / - .001	.88	✓			
3/4-20 THD		3/4-20	✓			
.69	± .030	.68	✓			
1.38	± .030	1.375	✓			
1.130	± .030	1.129	✓			
.88	± .030	.881	✓			
.69	± .030	.688	✓			
4.94	± .030	4.938	✓			
.79	± .030	.795	✓			
.12	± .03	.118	✓			
.88	± .030	.881	✓			
2.38	± .030	2.380	✓			
.34	± .030	.340	✓			
.50	± .030	.499	✓			
.379		.375	✓			
3.81	± .03	3.810	✓			
.25	± .03	.252	✓			
1.063	± .010	1.063	✓			
.88	± .030	.880	✓			
.37	± .030	.358	✓			
.36	± .030	.369	✓			
.98	± .030	.970	✓			
.61	± .030	.609	✓			

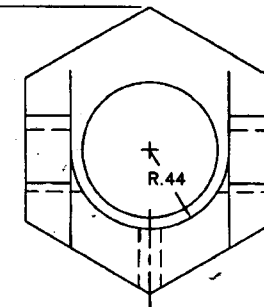
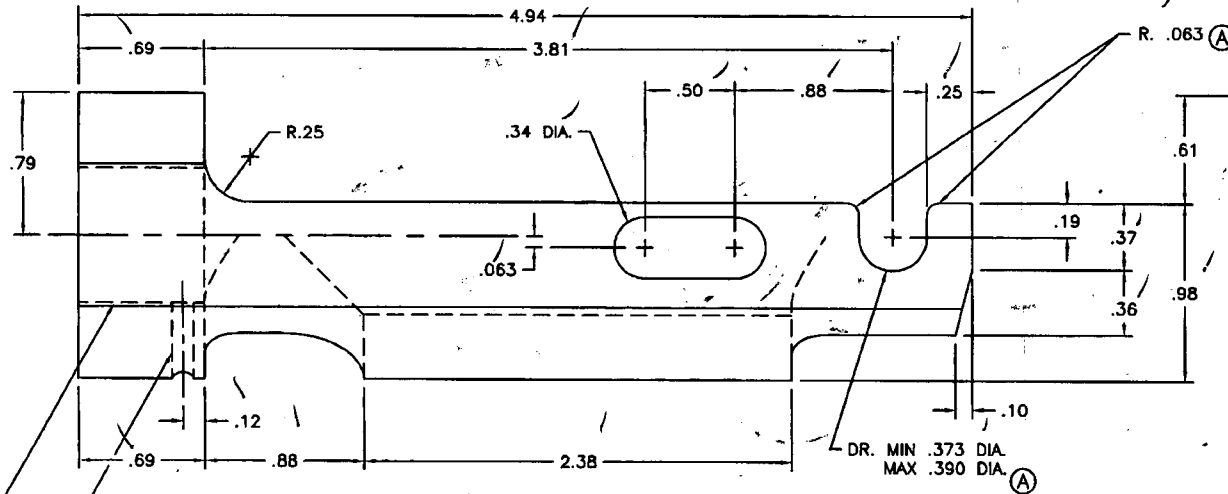
Measured by: JLM	Audited by: JLM	Prototype Approval: JLM
Date: 08/10/18	Date: 08/10/18	Date: 08/10/18

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

REVISION				APPROVED	DATE
LETTER	DFTSMAN	DATE	DESCRIPTION		
A	DNN	2/17/03	ADDED SMOOTH EDGES TO -001 & -003; REDUCED LENGTH OF -003 BY .125"; ADDED DRAIN HOLE TO -001; INCREASED DIA. OF AFT SLOT ON -001.		
MINOR CHANGE - FAR 21.95			CHECK D. MURPHY	2/17/03	



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WORK ORDER
NO. 4220



DR. .12 DIA. DRAIN HOLE
(NOTE: SPOTFACE IF REQ'D (A)
TO DRILL HOLE)

3/4"-20 THD,

-001 TUBE

NO.	REQ'D PER ASSY	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE
1		MS21209F4-15	INSERT				
		-005	PIVOT ARM (A)	1.00 DIA. x 3.56	2024-T4, T351 ALUM.		
		-003	LATCH (A)	1.11 x 3.50	2024-T4, T351 ALUM.		
		-001	TUBE (A)	1.38 HEX STK. x 4.94	2024-T4, T351 ALUM.		

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VENDOR PARTS.

UNLESS OTHERWISE SPECIFIED	DFTSMAN	DATE	TITLE
X.2.1	D. NELSON	2/18/02	STEP ACTUATOR COMPONENTS
X.2.3	D. MURPHY	2/18/02	
X.2.4			
X.2.5			
X.2.6			
X.2.7			
X.2.8			
X.2.9			
X.2.10			
X.2.11			
X.2.12			
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NO. REQ'D PER ASSY

UNLESS OTHERWISE SPECIFIED

DFTSMAN

CHECK

DATE

TITLE

STEP ACTUATOR COMPONENTS

DWG. SIZE

SCALE

REV.

ANODIZE IN ACCORDANCE WITH MIL-A-8625, TYPE III, CLASS 2 DYED BLACK.

NOTE:

41232-200-001

NEXT ASSEMBLY

HEAT TREAT

FRESH

DATE

REV.

41232-200-002

SHT 1 OF 3

REV.

A

Eva Aviation, Inc.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

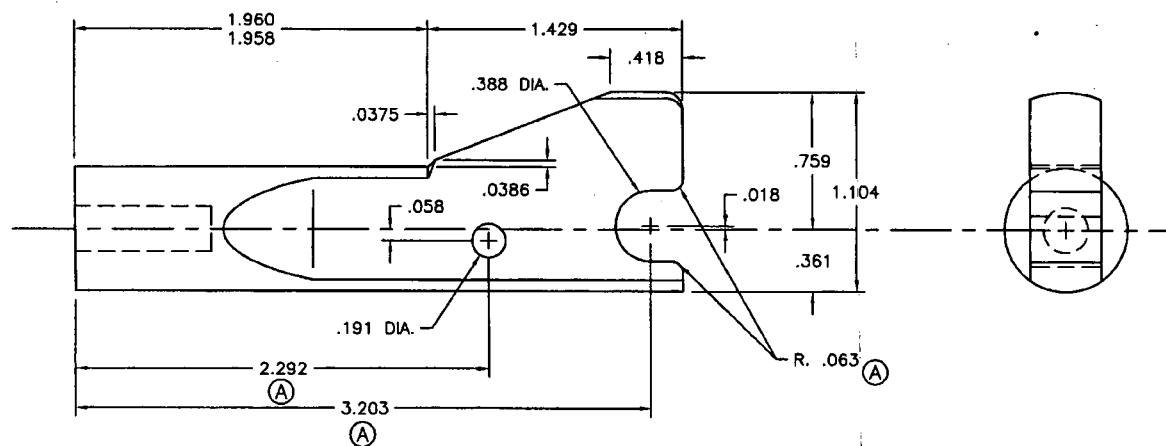
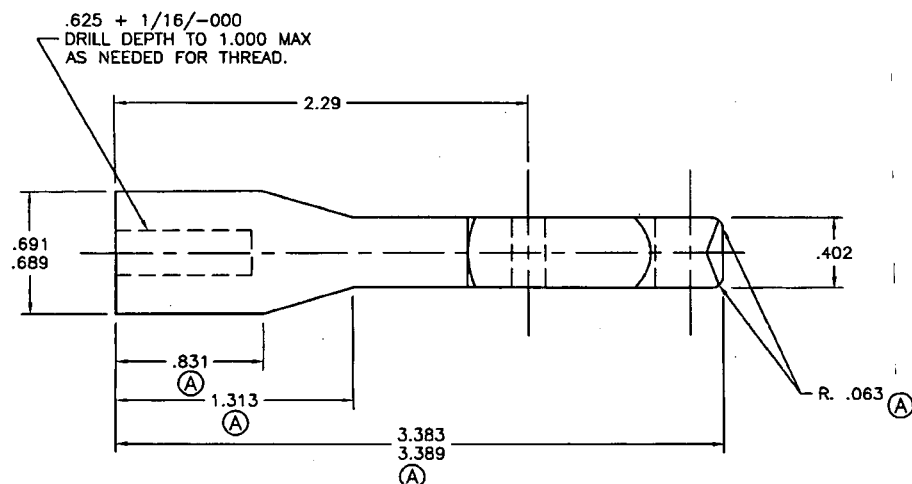
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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-003 LATCH

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Era Aviation, Inc.

STEP ACTUATOR COMPONENTS	SIZE C	DRG. NO. 41232-200-002 SHT 2 OF 3	REV. A
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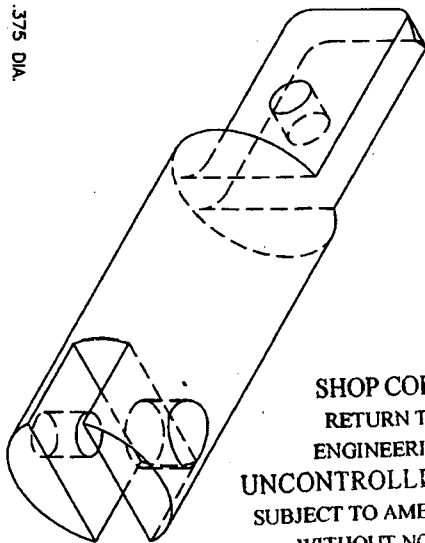
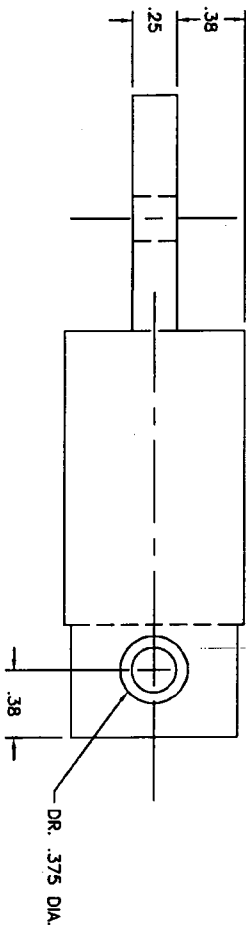
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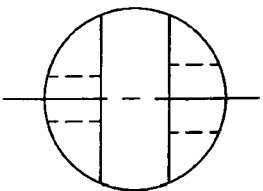
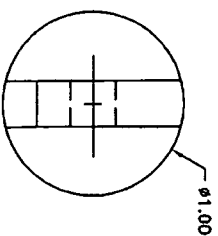
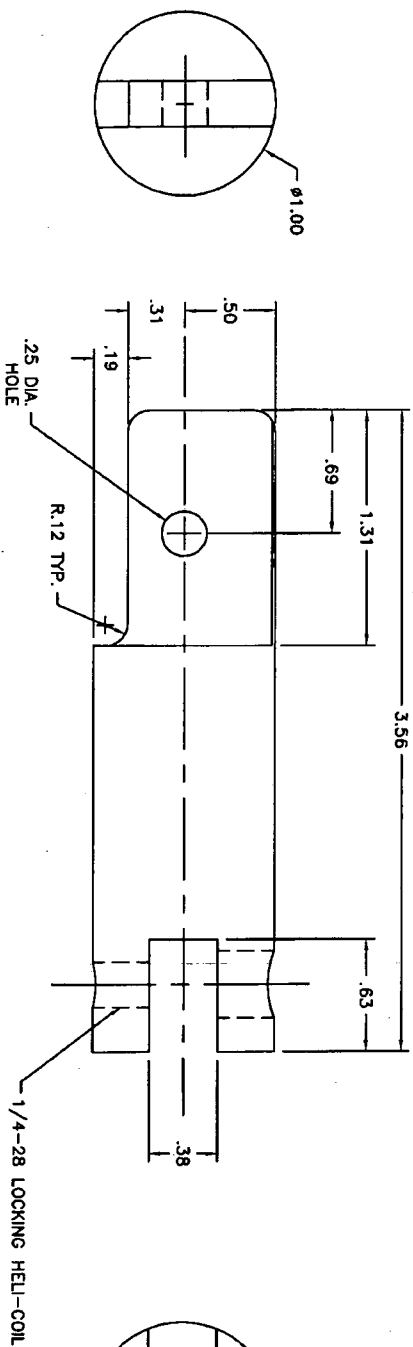
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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-005 PIVOT ARM

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TITLE STEP ACTUATOR COMPONENTS REV. 41232-200-002 SHT 3 OF 3 A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

ANODISATION et PEINTURE TNM INC.

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

approuvé NADCAP approved

69484

28-Oct-2008

CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY, ONTARIO

K6A 1K7

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE

NO. DE COMMANDE: 7433
PURCHASE ORDER/



ITEM	COMMANDE / ORDER	QUANTITE / QUANTITY	PART NUMBER / DESCRIPTION	PROCESS / TRAITEMENT
1	20	20	D3299-1 B42170	BLUE ANODIZE PER MIL-A-86251 TYPE II CLASS 2 ALL OVER
2	3	3	41232-200-002-001 B42265	BLACK ANODIZE PER MIL-A-8625F1 TYPE I CLASS 2

Solulso

CSL 1036

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.

Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed:

Directeur de la Qualité / Q.A. Manager

